



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400228-M-3
Job Sheet 165054



Part No: RBT400228-M-3

Job Qty: 2 ea

Part Name: Cylinder



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV 1 SHEET 3

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
RBT400228-M-3 Cylinder	DWG REV 1 SHEET 3		0.000	
M6061T6R6.500 6061-T6 Round Bar 6.500"			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	2 Ea	10/31/17	0.00	0.00	Start up container	
150	Outsource	2 pcs	10/31/17	0.00	0.00	Outsource4	
160	Packaging	2 pcs	10/31/17	0.00	0.00	Packaging2	
170	QC	2 pcs	10/31/17	0.00	0.00	QC5	
180	Packaging	2 pcs	10/31/17	0.00	0.00	Packaging3	
190	QC21-SA	2 Ea	10/31/17	0.00	0.00	QC21	

Part Op 150 - Issue P/O to ATG: PO 038842 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2

Descriptions: -Certification of Conformity is required

160 - #NAME?

180 - Identify as per QSI 44 section 5.5

JAN 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
RBT400228-M-3 B165054		4 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	RBT400228-M-3 B165054	4	2	0	0

Part Specifications

Specifications could not be found

Status: Stock

Part: **RBT400228-M-3 B165054**

Created: 9/30/17 12:03

PM DART.LAJEUNESSE.MARIE



Serial No: S000081

Printed By: Goldston, Justin 10/2/17 10:44 AM

Work Order Summary

Thursday, September 28, 2017 10:48:05 AM

Page 1 of 1

Criteria : Work Order ID: 165054 Item ID: RBT400228-M-3 Product Family MACHINING
Work Order Start Dates 8/28/2017 to 8/28/2017 11:59:59 PM Work Order Required Dates 8/28/2017 to 8/28/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID	165054	Required Qty	2.0000	Status Code	Released
Item ID	RBT400228-M-3	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Cylinder				
Current Acct Value	\$46.617				
Start Date	8/28/2017	Required Date	8/28/2017	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$74.679	\$0.000	\$46.617	\$46.617	100.00%
Labor	\$352.573	\$0.000	\$0.000	\$0.000	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$1,028.651	\$0.000	\$0.000	\$0.000	0.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$1,455.904	\$0.000	\$46.617	\$46.617	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M6061T6R6.500					
6061-T6 Round Bar 6.500"	0.7642		9/28/2017	0.7642	\$74.679
				Total Matl Amts:	\$74.679

Work Center CNC LATHE6

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LARO02		9/23/2017										
110			0.00	0.00	5.63	5.63	1.00	\$0.000	\$105.932	\$309.063	\$0.000	\$414.996
perr01												
		9/22/2017										
110			0.00	0.00	13.12	13.12	1.00	\$0.000	\$246.641	\$719.588	\$0.000	\$966.229
Total:			0.00	0.00	18.75	18.75	2.00	\$0.000	\$352.573	\$1,028.651	\$0.000	\$1,381.225

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Work Order ID 165054

165054

Page 1

Monday, August 14, 2017 1:40:18 PM

Item ID: RBT400228-M-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Cylinder

Start Date: 8/28/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 8/28/2017 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan:  Date: AUG 14 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
RBT400228-M	1

110		0.00							
110									
CNC LATHE6	Memo	0.00							
CNC LATHE 6 (SL-2500)	Machine as per folio <u>NB FB604</u>								
						2			DAS 39 9-89 17-09-23
									17-09-22
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
						2			DAS 39 9-89 17-09-23
									17-09-22
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
						2	10		mf 17/09/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause	FAULT CATEGORY										
<table style="width: 100%; border: none;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>	Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%; border: none;"> <tr> <td style="width: 33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> <tr> <td colspan="3"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
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☐ OTHER : _____											

Monday, August 14, 2017 1:40:18 PM

Item ID: RBT400228-M-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cylinder

Start Date: 8/28/2017 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 8/28/2017 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 QC5- Inspect part completeness to step on W/O

0.00

170

QC	Memo	0.00
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Quality Control

180	Identify as per dwg & Stock Location:_____	0.00
-----	--	------

0.00

180

Packaging	Memo	0.00
-----------	------	------

Packaging	Identify as per QSI 44 section 5.5
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190	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

0.00

*** 190 ***

QC	Memo	0.00
----	------	------

Quality Control

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																																																																													
Part No. _____ NCR No. _____		Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐																																																																																																																																																						
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Tribal Knowledge	☐		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish																																																																																																																																																						
LOA	☐		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread																																																																																																																																																						
Substation	☐		Process Improvement		Marks/Chatter		Drill Holes		Misaligned/off center		Turning Sequence																																																																																																																																																						
Past Expiry Date	☐		Manufacturing Process		OTHER : _____																																																																																																																																																												
Misidentified	☐		Past Due																																																																																																																																																														

Picklist Print

Page 1

Monday, August 14, 2017 1:40:25 PM

Work Order ID: 165054

165054

Parent Item: RBT400228-M-3

RBT400228-M-3

Parent Item Name: Cylinder

Start Date: 8/28/2017

Required Date: 8/28/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev.A 17.08.02 New issue DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R6.500		Purchased		No		110	f	0.0000	0.363	0.764211			
M6061T6R6 500										**			
6061-T6 Round Bar 6.500"													

6061 T6 R6 500

M138319

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DART AEROSPACE LTD		Work Order: 165051
Description: PSE, Mast Nut		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

RBT400228M-3

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	±.005	2.997	✓		Vern cal 02	
1.500	↓	1.4985	✓			
3.750	↓	3.747	✓			
1.875	↓	1.8735	✓			
Ø.764	+0.010 -0.001	.763	✓			
Ø.86 x 90°	↓ x 1/2°	.855 x 90°	✓			
Ø.511	+0.008 -0.001	.510	✓			
Ø.56 x 90°	↓ x 1/2°	.555 x 90°	✓			
1/4-20-2Bx65	GO - NOGO	GO	✓			
BC Ø6.000	±.005	6.000	✓			
Ø.2.18	±.010	2.178	✓			
6.480-6.460	N/A	6.470	✓			
5.540	±.005	5.537	✓			
4.36	±.010	4.360	✓			
3.85	↓	3.847	✓			
2.50	↓	2.510	✓			
.30 x 45°	±.010 x 1/2°	.308 x 45°	✓			
R.50	.010	.500	✓		Rad gage	

Measured by: DAS 39	Audited by: [Signature]	Preliminary Approval:
Date: 17-09-22	Date: 17/09/27	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

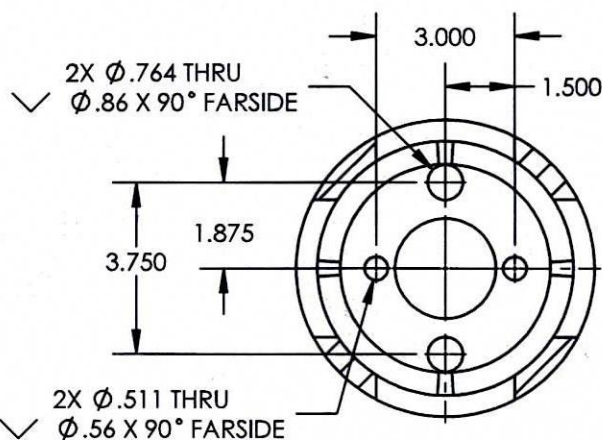
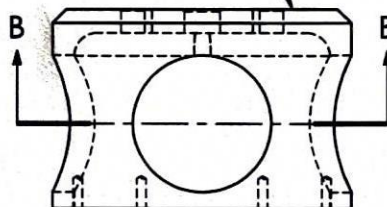
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

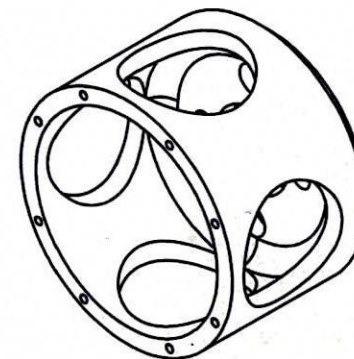
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

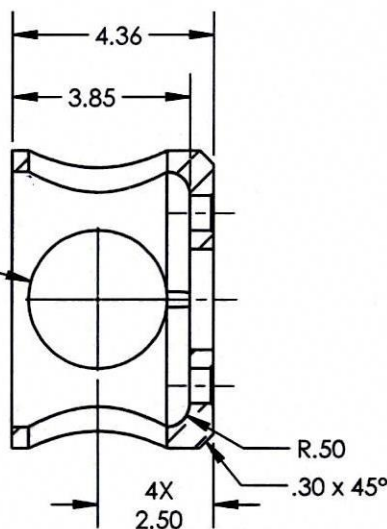
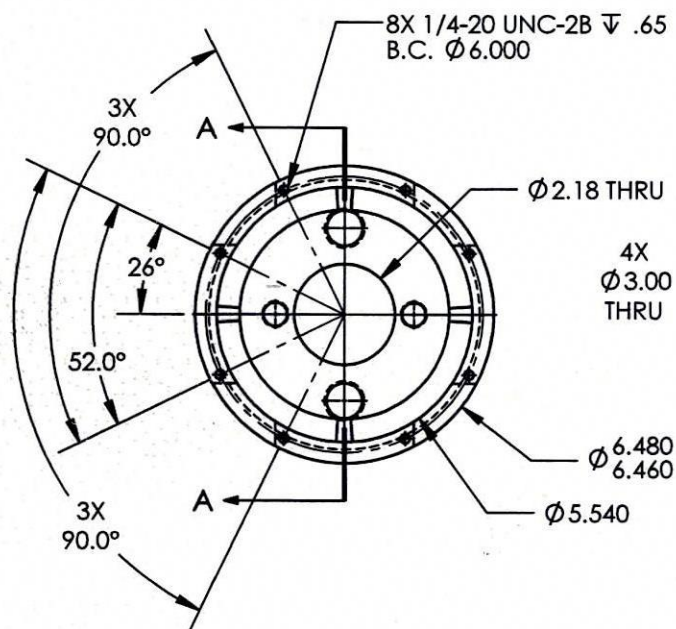
ENGRAVE T/N, S/N,
"MADE IN USA"



SECTION B-B



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16505112
AUG 14 2017



SECTION A-A

(-3)

CYLINDER

		TITLE	
		PSE, MAST NUT	
DWG NO.		REV	
RBT400228M-3		1	
MAT'L 6061-T6		DRAWN BY: WALLRICH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>J. Gilbert</i>	
.XXX ± .005		HEAT TREAT	
.XX ± .01		FINISH	
.X ± .1		RED ANODIZE	
1. BREAK ALL SHARP EDGES .015 x 45°		SPEC	
OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		BELL 407	
SCALE	1:4	DATE	4/8/2015
		SHEET 3 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Not Identified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too*Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038842

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038842

PO Date: 1/22/18

Due Date: 2/2/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
JAN 30 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170696	D5069-1-Rework	Hardpoint Adapter ISSUE P/O: _____ TO ATG ANODIZE BLACK AS PER DWG D5069 REV. B	Firmed	2/2/18	4 pcs	0 pcs	4 pcs	\$9.39/pcs	\$37.56
Line Item Note RUSH RUSH !!!!!										
2	170700	D5553-1-Rework	Bracket ISSUE P/O: _____ TO ATG ANODIZE BLACK AS PER DWG D5553 REV. A	Firmed	2/2/18	4 pcs	0 pcs	4 pcs	\$9.39/pcs	\$37.56
Line Item Note RUSH RUSH !!!										
3	168270	646.9812	Lower Cutter Deflector Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg 646.9800 Rev. A	Firmed	2/2/18	6 pcs	0 pcs	6 pcs	\$20.64/pcs	\$123.84
4	168234	646.3411	RH Wiper Deflector Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3400 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	Firmed	2/2/18	6 pcs	0 pcs	6 pcs	\$13.14/pcs	\$78.84
5	168233	646.3410	LH Wiper Deflector Issue P/O to ATG : 1- Hard Anodize, Color Black and Prime as per	Firmed	2/2/18	2 pcs	0 pcs	2 pcs	\$13.14/pcs	\$26.28



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914524

Date: 31-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
2 ea	Part: RBT400228M-3 Cylinder Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Job: 22414		Rev: 1 PO: PO038842 Line: 11
2 ea	Part: RBW6505G00831-3G-25 Mount Plate Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22415		Rev: 2 PO: PO038842 Line: 12
2 ea	Part: RTB400228M-1 Plate Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Job: 22416		Rev: 1 PO: PO038842 Line: 13
4 ea	Part: RB877528-4-3 Handle Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Job: 22409		Rev: 3 PO: PO038842 Line: 6
20 ea	Part: RB T102103-5 Retainer Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Seal Job: 22410		Rev: C PO: PO038842 Line: 7
12 ea	Part: RBD29905-15 Center Plate Anodize per MIL-A-8625F, Type II, Class 2, Red .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22412		Rev: 5 PO: PO038842 Line: 9 Made in Canada.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914524

Date: 31-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>01/02/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038842

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	170243	RB877528-4-3	Dwg 646.3400 Handle Issue P/O to ATG: ANODIZE COLOR BLACK, AS PER DWG RB877528-4-3 REV. 3	Firmed	2/2/18	4 pcs	0 pcs	4 pcs	\$7.24/pcs	\$28.96
7	170103	RB T102103-5	Retainer -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1 WATER SEAL	Firmed	2/2/18	20 pcs	0 pcs	20 pcs	\$7.24/pcs	\$144.80
8	170304	D2348	Wearplate (Key Way) Issue P/O: Black Anodize per Dwg D2348 Rev. C	Firmed	2/2/18	20 pcs	0 pcs	20 pcs	\$3.39/pcs	\$67.80
9	170385	RBD29905-15	Center Plate -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant	Firmed	2/2/18	12 pcs	0 pcs	12 pcs	\$10.78/pcs	\$129.36
10	168296	647.1816	Support LH ISSUE P/O: HARD ANODIZE, COLOR BLACK AND PRIME AS PER DWG 647.1800 REV. A	Firmed	2/2/18	4 pcs	0 pcs	4 pcs	\$14.14/pcs	\$56.56
11	165054	RBT400228M-3	Cylinder -Issue P/O to ATG: PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2 AS PER DWG RBT400228M-3 REV. 1	Firmed	2/2/18	2 pcs	0 pcs	2 pcs	\$10.78/pcs	\$21.56
12	169805	RBW6505G00831-3G-25	Mount Plate -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1, Water sealant AS PER DWG RBW6505G00831-3G- 25 REV. 2	Firmed	2/2/18	2 pcs	0 pcs	2 pcs	\$7.24/pcs	\$14.48
13	169323	RBT400228M-1		Firmed	2/2/18	4 pcs	0 pcs	4 pcs	\$10.78/pcs	\$43.12



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038842

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Plate : URF17-706 -Issue P/O to ATG: PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2 AS PER DWG RBT400228M-1 REV. 1							
Grand Total:										\$810.72

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CL

JB